

Work Order ID 147078 -2

147078

Page 1

Tuesday, May 31, 2016 10:57:27 AM

Item ID: D3910-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: X-Tube Lug

Stop *NS2*

Start Date: 6/3/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLSDate: MAY 31 2016

Tooling:

Date: _____

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	E								
110	Outsource process - Machining	0.00							DAS
110	HAAS CNC VERTICAL MACHINING #1								13
Outsource5	Memo	0.00							9-89
Outsource process - Machining	Issue P/O to Metec: <u>32585</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.10							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							DAS
130									38
QC	Memo	0.00							9-89
Quality Control									JUL 23 2016

Split-2-
10x

300

JUN 02 2016

10x 50/6-715

(10)

Work Order ID 147078

Tuesday, May 31, 2016 10:57:27 AM

147078

Page 2

Item ID: D3910-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: X-Tube Lug
 Start Date: 6/3/2016 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.05							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							

Picklist Print

Tuesday, May 31, 2016 10:57:31 AM

Page 1

Work Order ID: 147078

147078

Parent Item: D3910-3

D3910-3

Parent Item Name: X-Tube Lug

Start Date: 6/3/2016

Required Date: 6/17/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-3P *D3910-3P* Crosstube Lug		Purchased	No				Each	0.0000		30			
D2423 *D2423* Lug Extrusion		Manufactured	No				f	246.9529		4.105263			

DAS
13
8-89

AUG 02 2016

Location

Loc Qty

Loc Code

Metec

127892

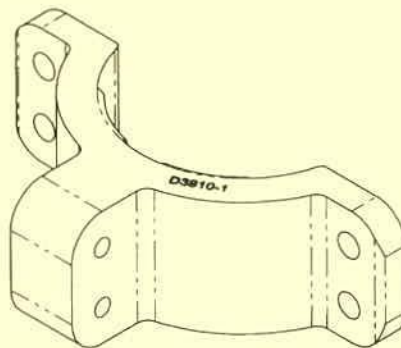
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246.9529237

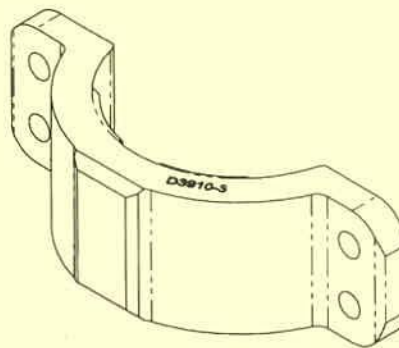
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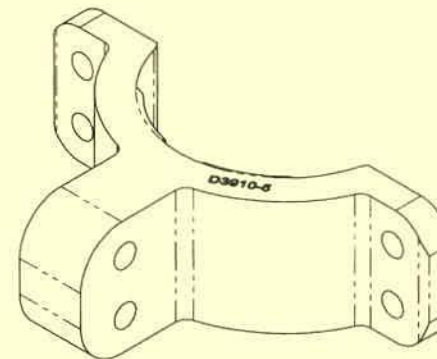
30
10x
SP/6-7-15
DAS
13
8-89
AUG 02 2016



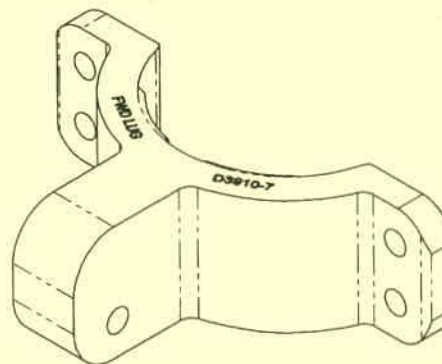
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

RELEASED

2014 JUN 05

ECN 14-572

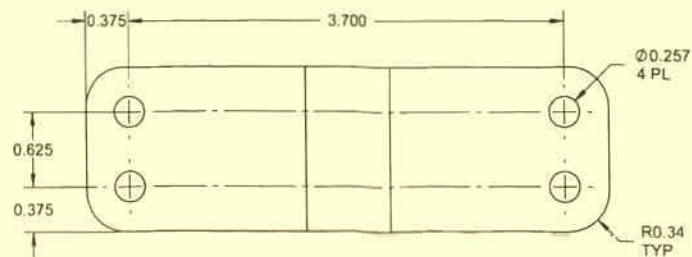
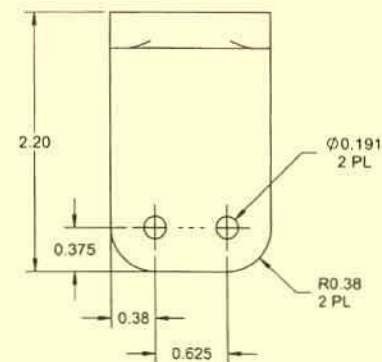
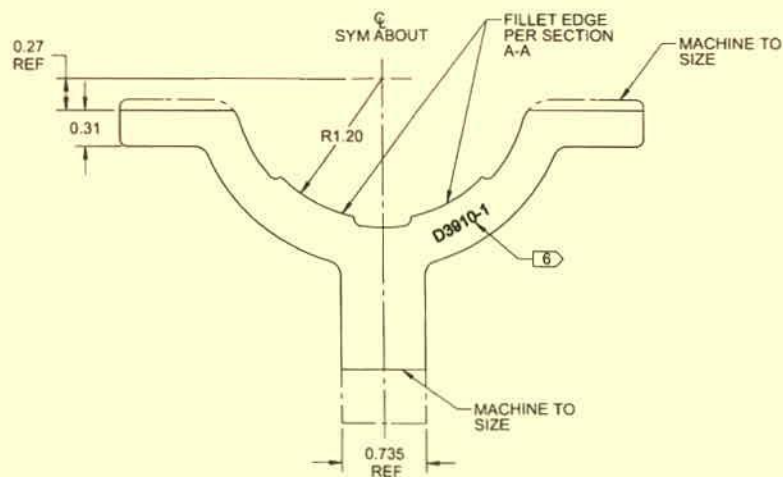
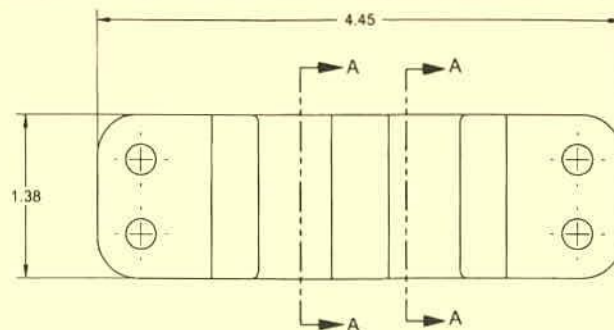
147078 MJS
16-05-31

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE REASON: EASE OF INSTALLATION	AJS	13.08.14
C	ADD -5	AJS	13.08.08
B	Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D390-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

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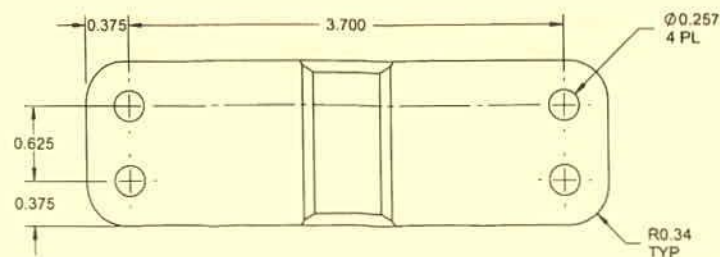
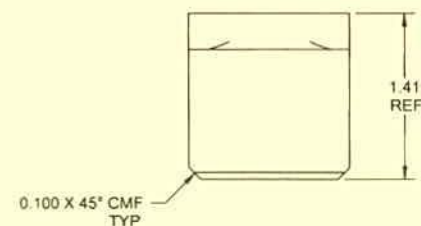
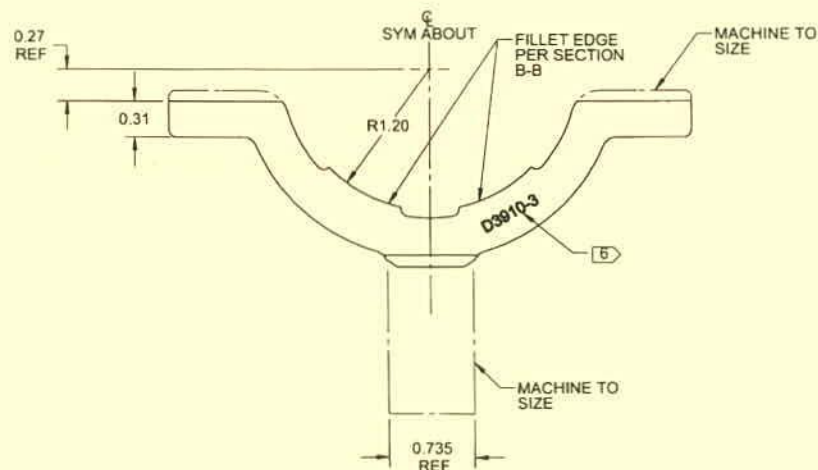
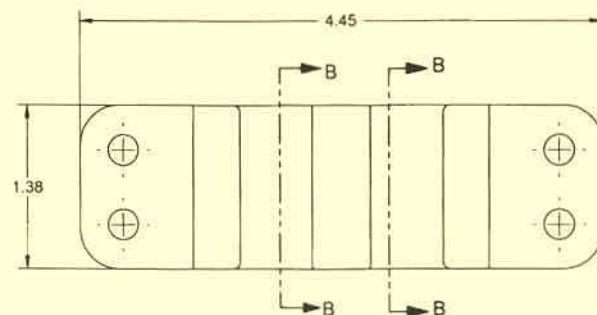
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B



D3910-3 X-TUBE LUG

RELEASED

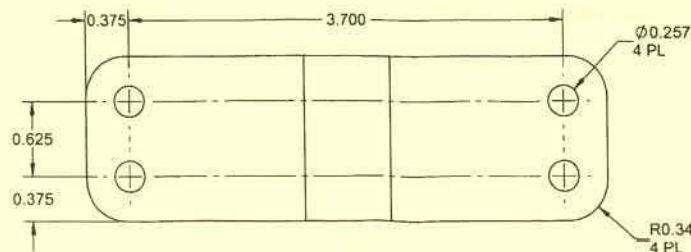
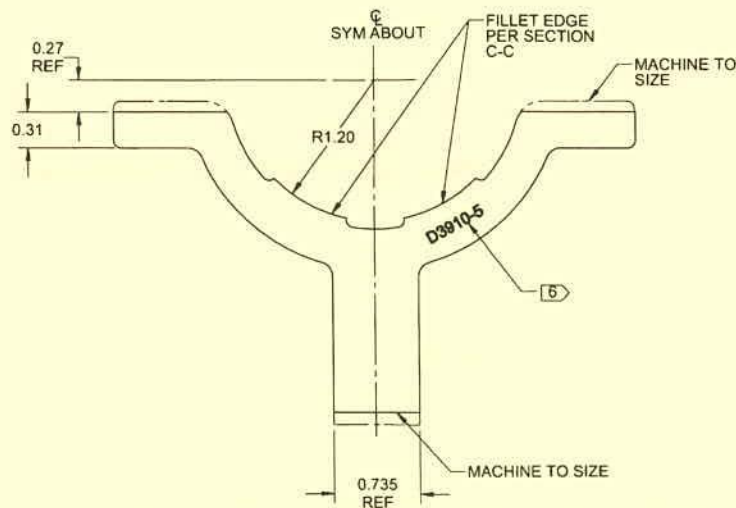
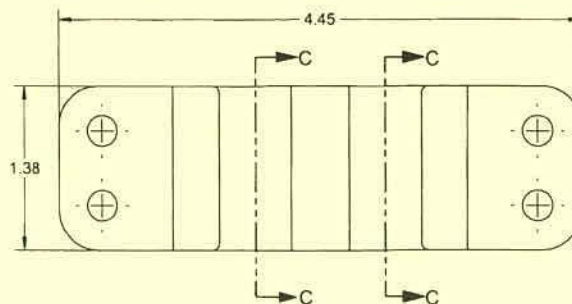
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MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 3 OF 5
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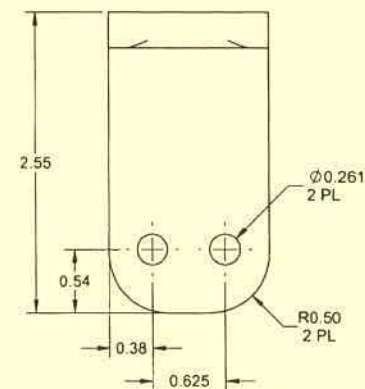


ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION C-C



D3910-5 X-TUBE LUG



RELEASED

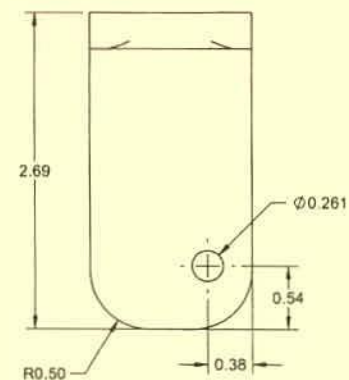
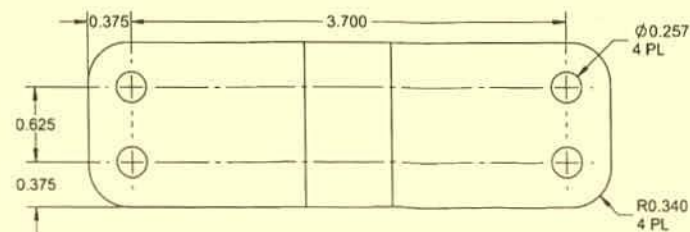
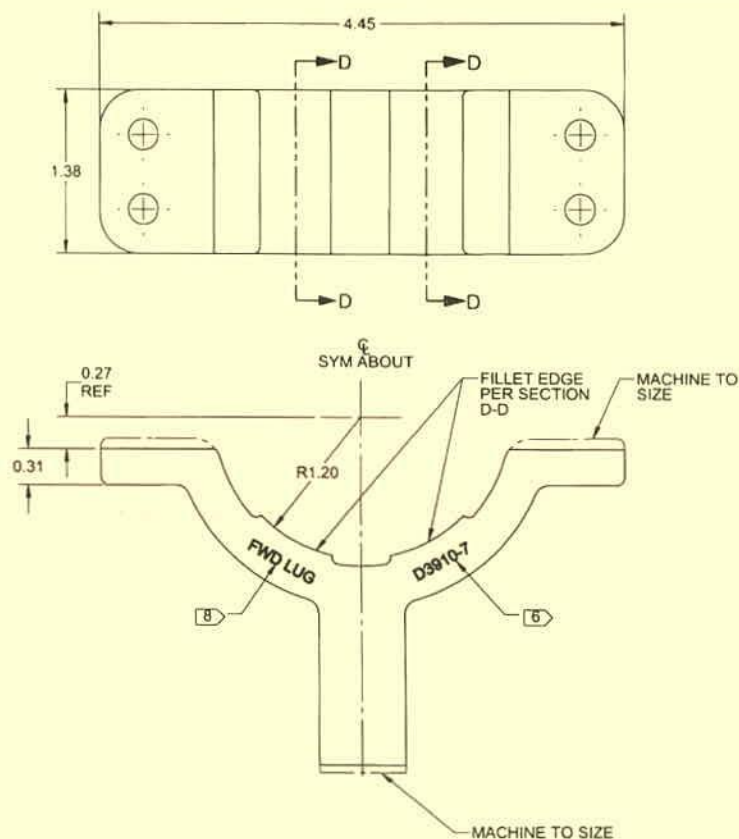
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CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E SHEET 4 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



RELEASED

2014 JUN 05 *q*

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CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	SCALE	NTS
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DATE	14.05.16		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32585

Purchase Order Date 6/2/2016

PO Print Date 6/2/2016

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

JUN 03 2016

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3910-3P AS PER DWG D3910 REV. E B147078 ANODIZE AND PAINT AS PER QSI 005	Crosstube Lug	6/17/2016 Yes 6/17/2016		30.00 Each	\$16.10	\$483.00
Line Total:							\$483.00
2	D3235-1P AS PER DWG D3235 REV. A B147073 ANODIZE AND PAINT AS PER QSI 005	Lug	6/17/2016 Yes 6/17/2016	FN	100.00 Each	\$15.00	\$1,500.00
Line Total:							\$1,500.00

Note:

6/2/2016



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21308
Date: Jul 15, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 32585	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: Jul 15, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-3 ✓ Crosstube Lug, as per drawing D3910 RevE Alodine and paint as per QSI 005	Each	30	10 ✓	
D3235-1 ✓ Mounting Lug, as per drawing D3235 RevA Alodine and paint as per QSI 005	Each	100	100 ✓	

SP16-7-15

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D3910-3	Lug	32585
100	D3235-1	Lug	32585

MATERIAL: supplied by DART B131451

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, July 15, 2016